

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026781**Date Inspected:** 29-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bikepath Belvedere**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on the jobsite between the times noted above to randomly observe Quality Control (QC) personnel monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations made on this date were:

CCO: 178 - Description: Modify the existing Bike Path belvederes, Bike Path maintenance traveler, and existing maintenance traveler rail to allow passage of the traveler on the Skyway portion of the East Span SFOBB.

This QA Inspector randomly observed ABF welder Mr. Jason Collins performing the Air-Carbon-Arc gouge operation to remove the remnant material - (at least 10 mm of material) of the section of the architectural beam that was previously removed by others from the bottom panel of the Bike Path at Pier Location 12E - (east side location). This QA Inspector observed that the removal of remnant material did not damage the remainder of the Bike Path bottom panel. The steel surface was ground flush and there were no areas that were damaged that required any weld repairs to be performed.

Afterwards, this QA Inspector randomly observed ABF welder Mr. Gil Peralta (Welder ID 9543) performing the fillet weld operation on the new cover plate to the remaining architectural beam of the Belvedere at Pier Location 12E - (east side location) per the Shielded Metal Arc Welding (SMAW) process in the (3F) vertical and (4F) overhead positions.

This QA Inspector observed that before, during, and after the fillet weld operation was completed that no QC Inspector was present to verify that the preheat temperature was at the required minimum temperature of 70 degrees F and that the welding parameters (Amps, Volts and Travel Speed) were previously established and in accordance with WPS-F1200A. The Contractor's QC Inspector did not inspect and approve the joint preparation,

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## WELDING INSPECTION REPORT

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the assembly practice, the welding technique, the joint fit-up, and the performance of ABF welder Mr. Gil Peralta (Welder ID 9543).

This QA Inspector observed that the Contractor's QC Inspector was not present from 7:00 to 11:00 and at approximately 11:10, the Contractors' QC Inspector Mr. Bernie Docena arrived at Pier Location 12E (west side location). This QA Inspector did not generate an Incident Report on this date for the above non-compliance due to ABF Quality Control Manager Mr. Chuck Kanipicky's oversight in communication to Quality Control dispatcher Mr. Bill Norris to schedule a Quality Control Inspector before the start of the welding operation at Pier Location 12E (east side location). The work at Pier Location 12E (west side location) on the architectural beam of the Belvedere was in process at the end of this QA Inspectors' shift.

CCO: 178- Description: Modify the existing Bike Path belvederes, Bike Path maintenance traveler, and existing maintenance traveler rail to allow passage of the traveler on the Skyway portion of the East Span SFOBB.

This QA Inspector observed ABF personnel performing the drilling operation for the installation of additional mounting bolts - (19 mm diameter) in the existing box girder web plate of the Bike path box girder and the Bike Path maintenance traveler outer rail. This QA Inspector observed that ABF personnel were in-process on the drilling operation and bolting operation and were working towards Pier location 12E at the end of this QA Inspectors' shift.



### Summary of Conversations:

This QA Inspector notified ABF's QC Inspector Mr. Bill Norris at approximately 7:45 via phone message to notify that there were welding operations being performed at Pier 12E (east side location) on the architectural beam of the Belvedere.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Peterson, Art

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer

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